

539

DART AEROSPACE LTD	Work Order:	24172
Description: Lug Assembly	Part Number:	D3405-043
Dwg: D3405 Rev. A	Qty:	8 u
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AP	05/09/07	8
2	PG	Issue P/O: 2008729 Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3405 Material release note is required Identify as D3405-3	AP	05/09/30	8
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	CL	05/10/18	8
4	QC6	Inspect dimensions as per Dwg D3405	2	05-10-18	8
5	GA	Deburr		N/A	
6	GB	Form using DT8204 as per Dwg D3405	SB	05/10/19	8
7	QC5	Inspect work to Step 6	2	05-10-19	8
8	WS	Weld as per Dwg D3405 Pick: Qty Part number Description Batch 1 D3404-1 Lug 324611 A/R SS Rod M13066 Identify as D3405-043	CL	05-10-24	8
9	QC9	Visual welding inspection	MA	05/10/24	8
10	QC5	Inspect work to Step 9	MA	05/10/24	8
11	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	MA	05 10 25	8
12	QC3	Inspect Powder Coat	CL	05/10/25	8
13	ST	Identify and Stock	u	05/10/25	8
14	AC	Cost / part: 35.43	545	05-10-26	8
15	DC	Close W/O 35.43 Inspect Level 21	CL	05/10/26	8

Rev	Date	Change	Revised By	Approved
A	05.09.01	New issue	KJ/JLM	

RELEASED
21/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

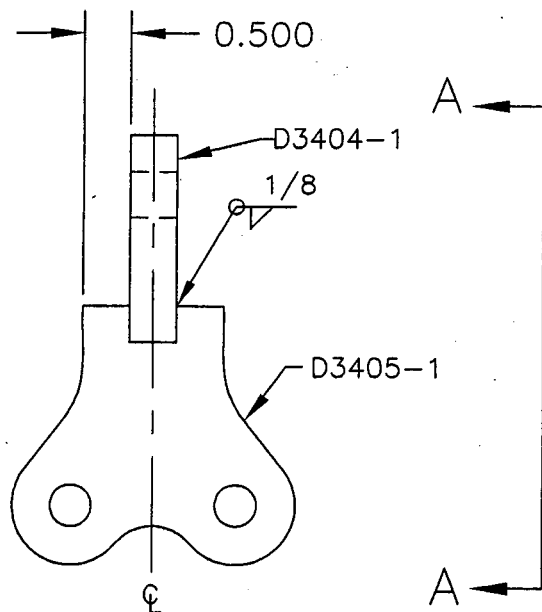
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/10/26

NOTE: Date & initial all entries

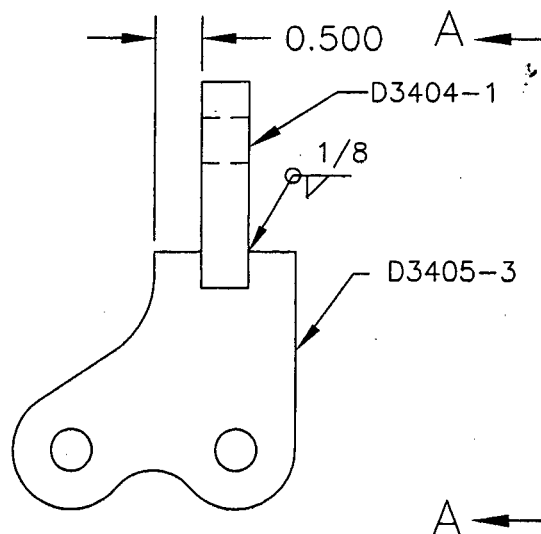
QA: N/C Closed: _____ Date: _____



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08	TITLE GHW LUG ASSEMBLY		SCALE 1:2
A	05.03.08	NEW ISSUE	



D3405-041 LUG ASSEMBLY



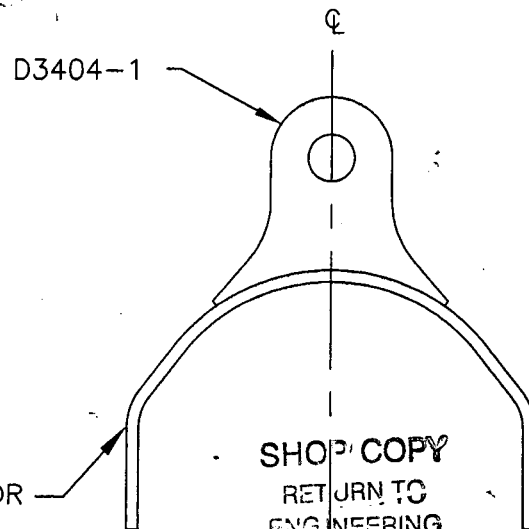
D3405-043 LUG ASSEMBLY

PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05-08-09

D3405-1 OR
D3405-3



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SUBMITTAL AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 24172

D3405-041/-043 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 01, 2005
10:49 am

Work Order No : 0024172
Project Name : D3405-043
Project For : ~~GHW-LUG~~ WK539
Work Order Type : Main
Main WO Number :
House Part Number : D3405-043
Description : Lug Assembly
Manufactured : No
Amount Req'd : ~~0.00~~ 0
Amount Done : 0
Start Date : 08-31-05
Est Finish Date : 09-29-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



P41123PC002
 Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I,
 Paragraph 4.3 by TÜV Anlagentechnik GmbH (Notified Body Identification No. 0035)
 Inspection Certificate EN10204-3.1B

Taiyuan Iron and Steel(Group)Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China
 TEL: (0351)3013328 FAX: (0351)3017816
 http://www.tisco.com.cn
 E_mail: tgbxg@tisco.com.cn

INSPECTION CERTIFICATE

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	200412110	
DATE OF ISSUE	/ /	

CUSTOMER
 Marubeni-Itochu Steel CA.

CONTRACT NO.
 Y-947

DATA OF
 2004/12/20

Product

Melting furnace

Inspectors stamp

Mark of the Manufacturer

COIL

E+VOD



Shanxi Taiyuan Stainless Steel Co.,Ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
1	4405025	4A11-303-12B	1	11GA x 48 x C	4358
2	4404509	4A10-356-12B	1	14GA x 48 x C	3920
3	QHLL0164	4A12-141-3ZJ	1	14GA x 48 x C	4972
4	Y408037	4A12-373-4ZD	1	12GA x 48 x C	4382
5	Y408037	4A12-374-4ZD	1	12GA x 48 x C	4347
6	Y408037	4A12-375-4ZD	1	12GA x 48 x C	4257
7	4405608	4A12-341-1ZJ	1	12GA x 48 x C	3793

Chemical Composition

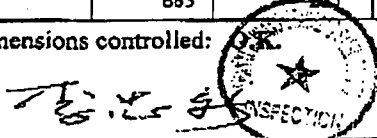
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4405025	0.060	0.470	1.340	0.020	0.002	18.050	8.100				0.059
4404509	0.050	0.470	1.350	0.021	0.002	18.080	8.120				0.060
QHLL0164	0.052	0.546	1.077	0.027	0.003	18.300	8.080				0.044
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
4405608	0.060	0.510	1.350	0.021	0.002	18.090	8.100				0.055

Mechanical Properties

Test No.	Tensile R _m N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4405025-T	610	255		65		83		
4404509-T	655	265		61.5		84		
QHLL0164-T	660	275		58.5		83		
Y408037-T	660	260		64		85		
Y408037-T	660	260		64		85		
Y408037-T	660	260		64		85		
4405608-T	665	265		61.5		84		

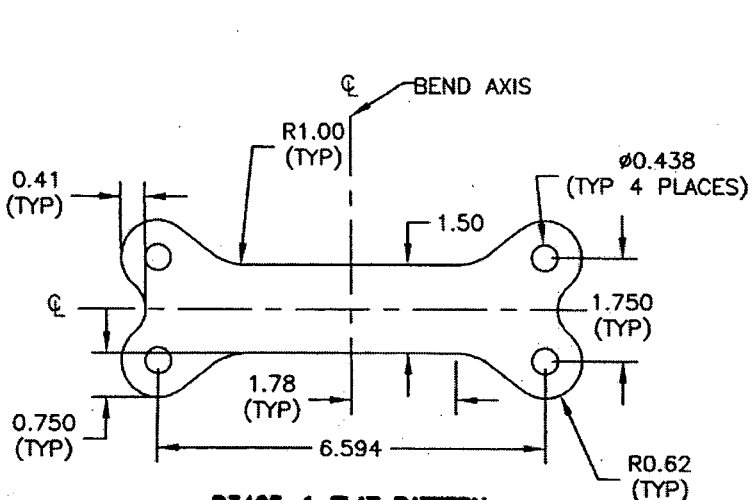
Surface and dimensions controlled:

Work Inspector:

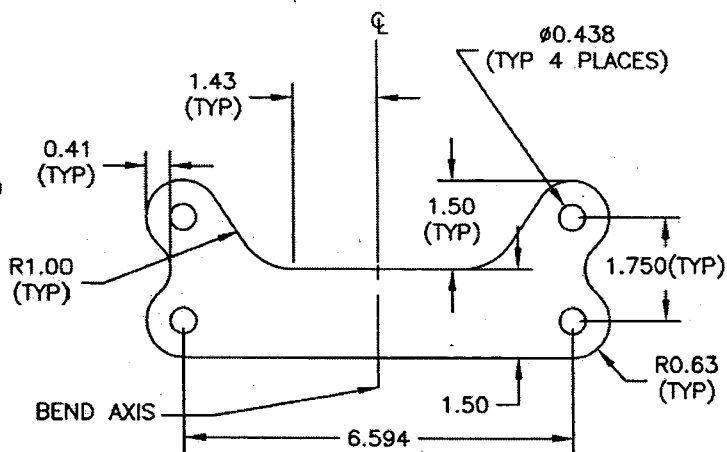


DART

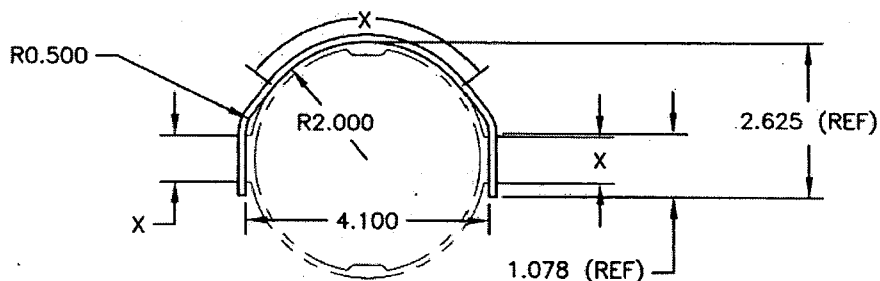
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. A
PH	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 2
DATE		D3405	SCALE
05.03.08		GHW LUG ASSEMBLY	1:3



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO
WITHIN 0.010 OF THE OUTSIDE
PROFILE OF THE D2500-1 EXTRUSION IN THE
AREAS INDICATED 'X' ABOVE.

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 24171

RELEASED
05.08.04